

Date: Monday, 31/03/2008 1:46:52 PM
User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD		
Job Number	38254					
Estimate Number	12712					
P.O. Number	:		Part Number	D35371		
This Issue	31/03/2008	S.O. No. :	Drawing Number	D3537 REV C		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	C		
Previous Run	37749		Material	:		
Written By	<i>JLM 08.03.31</i>		Due Date	07/04/2008	Qty:	16 Um: Each
Checked & Approved By						
Comment	Est Rev:A New Issue 07-02-14 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 2.7
Comment: Qty.: 0.1113 sf(s)/Unit Total : 1.7808 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>1075B</u> <u>FB 8-3-31</u>		
" 2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> <u>FB 8-3-31</u> Prog Rev: <u>C</u> <u>24</u>		
2-Deburr if necessary <u>FB 8-3-31</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>FB 8-3-31</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>5 026101</u> <u>424</u> <u>24</u>		
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1 <u>SB 08/04/01</u> <u>24</u>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 38254		Part Number: D35371
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		<p>Qty Description Batch A/R 2059B Hardcoat M107e51. 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary</p> <p>08-04-02 </p>
7.0	QC10	VISUAL INSPECTION OF GROUND WELDS
Comment: VISUAL INSPECTION OF GROUND WELDS		<p>08/04/02 </p>
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<p>08/04/02 </p>
9.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<p>M 100442 </p> <p>08-04-02 </p>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<p>08-04-02 </p>
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP-26		<p>08-04-02 </p>
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<p>08/04/03 </p>
Job Completion		
		<p>U 08-04-03 </p>

DART AEROSPACE LTD	Work Order:	38254
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

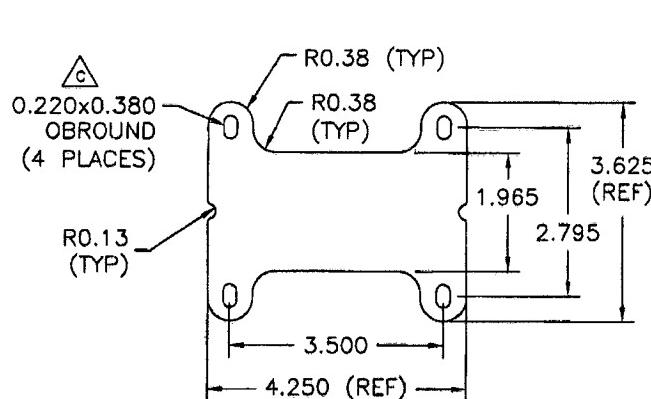
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

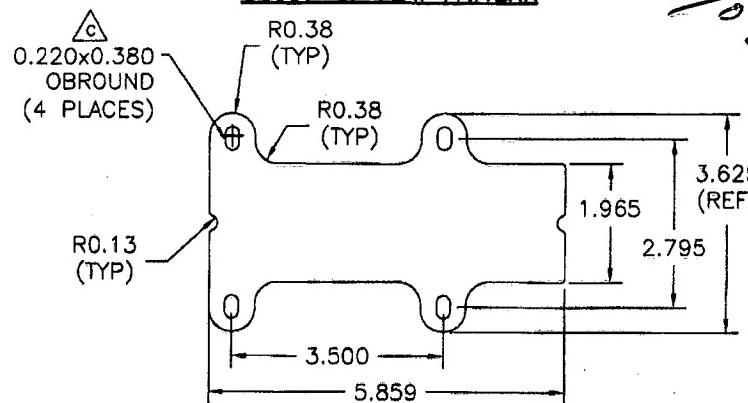
Measured by:	<u>LB</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-3-31	Date:	08/09/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	JL/SJ

D3537-1F FLAT PATTERN

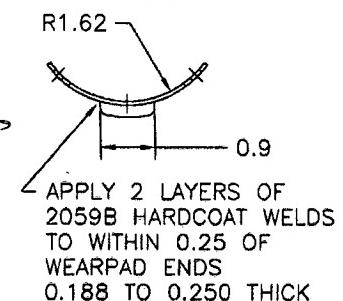


D3537-3F FLAT PATTERN

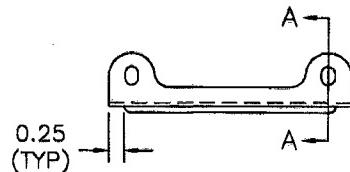


CW 38252

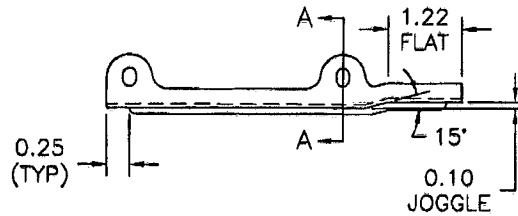
SECTION A-A



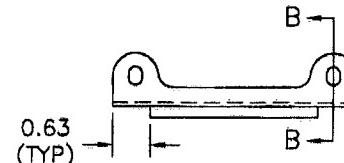
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



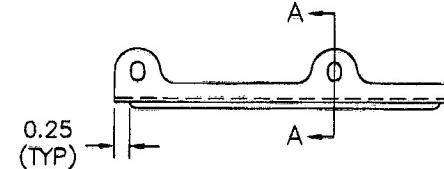
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. REV. C D3537 SHEET 1 OF 1
DATE	TITLE	SCALE 07.04.13 WEARPAD 1:2